



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D4931-5****Job Sheet 202249****Part No:** D4931-5**Job Qty:** 12 pcs**Part Name:** Engine Fitting (for B3e models)**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/22/19**Job Tracking No:****Due Date:** 11/6/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV A SHEET 3 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD**Ship Via:****Bill of Materials****Job Routing**

| Op No | Operation  | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |            |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 100   | Doosan - 1 | 12 pcs | 11/6/19    | 11/6/19  | 1.00      | 10.43   | Doosan - 1            |           | De       |
| 110   | QC 2       | 12 pcs | 11/6/19    | 11/6/19  | 0.00      | 0.00    | QC 2 - 1              |           |          |
|       |            |        |            |          |           |         | QC 2 - 12             |           |          |
|       |            |        |            |          |           |         | QC 2 - 14             |           |          |
|       |            |        |            |          |           |         | QC 2 - 17             |           |          |
|       |            |        |            |          |           |         | QC 2 - 19             |           |          |
|       |            |        |            |          |           |         | QC 2 - 2              |           |          |
|       |            |        |            |          |           |         | QC 2 - 20             |           |          |
|       |            |        |            |          |           |         | QC 2 - 22             |           |          |
|       |            |        |            |          |           |         | QC 2 - 23             |           |          |
|       |            |        |            |          |           |         | QC 2 - 25             |           |          |
|       |            |        |            |          |           |         | QC 2 - 32             |           |          |
|       |            |        |            |          |           |         | QC 2 - 33             |           |          |
|       |            |        |            |          |           |         | QC 2 - 35             |           |          |
|       |            |        |            |          |           |         | QC 2 - 39             |           |          |
|       |            |        |            |          |           |         | QC 2 - 4              |           |          |
|       |            |        |            |          |           |         | QC 2 - 40             |           |          |
|       |            |        |            |          |           |         | QC 2 - 44             |           |          |
|       |            |        |            |          |           |         | QC 2 - 45             |           |          |
|       |            |        |            |          |           |         | QC 2 - 48             |           |          |
|       |            |        |            |          |           |         | QC 2 - 49             |           |          |
|       |            |        |            |          |           |         | QC 2 - 50             |           |          |
|       |            |        |            |          |           |         | QC 2 - 51             |           |          |
|       |            |        |            |          |           |         | QC 2 - 52             |           |          |
|       |            |        |            |          |           |         | QC 2 - 57             |           |          |
|       |            |        |            |          |           |         | QC 2 - 62             |           |          |
|       |            |        |            |          |           |         | QC 2 - 63             |           |          |
|       |            |        |            |          |           |         | QC 2 - 8              |           |          |
|       |            |        |            |          |           |         | QC 2 - 66             |           |          |
|       |            |        |            |          |           |         | QC 2 - 64             |           |          |



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

**Container No:** S229096**Part:** D4931-5**Job No:** 202249**Serial No/Batch:** S229096**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 11/02/19

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|                                 |        |         |      |      |  |                             |             |
|---------------------------------|--------|---------|------|------|--|-----------------------------|-------------|
|                                 |        |         |      |      |  | QC 2 - 65                   |             |
|                                 |        |         |      |      |  | QC 2 - 5                    |             |
|                                 |        |         |      |      |  | QC 2 - 71                   |             |
|                                 |        |         |      |      |  | QC 2 - 73                   |             |
|                                 |        |         |      |      |  | QC 2 - 69                   |             |
| 112 Conventional Mill - 1 - B4B | 12 pcs | 11/6/19 | 0.00 | 4.96 |  | Conventional Mill - 1 - B4B | 11/11/14    |
|                                 |        |         |      |      |  | Conventional Mill - 2 - B4B |             |
| 115 QC 2                        | 12 pcs | 11/6/19 | 0.00 | 0.00 |  | QC 2 - 1                    |             |
|                                 |        |         |      |      |  | QC 2 - 12                   |             |
|                                 |        |         |      |      |  | QC 2 - 14                   |             |
|                                 |        |         |      |      |  | QC 2 - 17                   |             |
|                                 |        |         |      |      |  | QC 2 - 19                   |             |
|                                 |        |         |      |      |  | QC 2 - 2                    |             |
|                                 |        |         |      |      |  | QC 2 - 20                   |             |
|                                 |        |         |      |      |  | QC 2 - 22                   |             |
|                                 |        |         |      |      |  | QC 2 - 23                   |             |
|                                 |        |         |      |      |  | QC 2 - 25                   |             |
|                                 |        |         |      |      |  | QC 2 - 32                   |             |
|                                 |        |         |      |      |  | QC 2 - 33                   |             |
|                                 |        |         |      |      |  | QC 2 - 35                   |             |
|                                 |        |         |      |      |  | QC 2 - 39                   |             |
|                                 |        |         |      |      |  | QC 2 - 4                    |             |
|                                 |        |         |      |      |  | QC 2 - 40                   |             |
|                                 |        |         |      |      |  | QC 2 - 44                   |             |
|                                 |        |         |      |      |  | QC 2 - 45                   |             |
|                                 |        |         |      |      |  | QC 2 - 48                   |             |
|                                 |        |         |      |      |  | QC 2 - 49                   |             |
|                                 |        |         |      |      |  | QC 2 - 50                   |             |
|                                 |        |         |      |      |  | QC 2 - 51                   |             |
|                                 |        |         |      |      |  | QC 2 - 52                   |             |
|                                 |        |         |      |      |  | QC 2 - 57                   |             |
|                                 |        |         |      |      |  | QC 2 - 62                   |             |
|                                 |        |         |      |      |  | QC 2 - 63                   | 11/11/14    |
|                                 |        |         |      |      |  | QC 2 - 8                    |             |
|                                 |        |         |      |      |  | QC 2 - 66                   |             |
|                                 |        |         |      |      |  | QC 2 - 64                   |             |
|                                 |        |         |      |      |  | QC 2 - 65                   |             |
|                                 |        |         |      |      |  | QC 2 - 5                    |             |
|                                 |        |         |      |      |  | QC 2 - 71                   |             |
|                                 |        |         |      |      |  | QC 2 - 73                   |             |
|                                 |        |         |      |      |  | QC 2 - 69                   |             |
| 120 QC 8                        | 12 pcs | 11/6/19 | 0.00 | 0.00 |  | QC 8 - 12                   | cm 19/11/04 |
|                                 |        |         |      |      |  | QC 8 - 14                   |             |
|                                 |        |         |      |      |  | QC 8 - 17                   |             |
|                                 |        |         |      |      |  | QC 8 - 20                   |             |
|                                 |        |         |      |      |  | QC 8 - 25                   |             |
|                                 |        |         |      |      |  | QC 8 - 3                    |             |
|                                 |        |         |      |      |  | QC 8 - 32                   |             |
|                                 |        |         |      |      |  | QC 8 - 33                   |             |
|                                 |        |         |      |      |  | QC 8 - 35                   |             |
|                                 |        |         |      |      |  | QC 8 - 39                   |             |
|                                 |        |         |      |      |  | QC 8 - 4                    |             |
|                                 |        |         |      |      |  | QC 8 - 44                   |             |
|                                 |        |         |      |      |  | QC 8 - 45                   |             |
|                                 |        |         |      |      |  | QC 8 - 49                   |             |
|                                 |        |         |      |      |  | QC 8 - 58                   |             |
|                                 |        |         |      |      |  | QC 8 - 8                    |             |

|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              |                         |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------|----------|---------|--------------|-------------------------|
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         | QC 8 - 9     |                         |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         | QC 8 - 68    |                         |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         | QC 8 - 67    |                         |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         | QC 8 - 1 (A) |                         |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         | QC 8 - 47    |                         |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         | QC 8 - 40    |                         |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         | QC 8 - 52    |                         |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         | QC 8 - 23    |                         |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         | QC 8 - 57    |                         |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         | QC 8 - 76    |                         |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         | QC 8 - 61    |                         |
| 130                                                                                                                                                                                                                                                                                                                                                                                               | Packaging 3-2 - Stock - B4B | 12 pcs ✓ | 11/6/19 | 0.00 0.00    | Packaging 3 - 1 - B4B   |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 2 - B4B   |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 3 - B4B ✓ |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 4 - B4B   |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 5 - B4B   |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 6 - B4B   |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 7 - B4B   |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 8 - B4B   |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 9 - B4B   |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 10 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 11 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 12 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 13 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 14 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 15 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 16 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 17 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 18 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 19 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 20 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 21 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 22 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 23 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 24 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 25 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 26 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 27 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 28 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 29 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 30 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 31 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 32 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 33 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 34 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 35 - B4B  |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | Packaging 3 - 36 - B4B  |
| 140                                                                                                                                                                                                                                                                                                                                                                                               | QC 21 - SA                  | 12 pcs ✓ | 11/6/19 | 0.00 0.00    | QC 21 - SA - 21 ✓       |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | QC 21 - SA - 70         |
|                                                                                                                                                                                                                                                                                                                                                                                                   |                             |          |         |              | QC 21 - SA - 53         |
| Part Op 100 - (Doosan Lathe) Machine as per folio FB210<br>Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)<br>112 - (Manufacture as per dwg) DRILL HOLES AS PER REQUIRED<br>115 - QC2- Inspect parts off machine FAI/FAIB)<br>120 - QC8- Inspect parts - second check)<br>130 - Identify as per dwg & Stock Location: _____)<br>140 - (QC21- Final Inspection - Work Order Release) |                             |          |         |              |                         |

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| Job BOM                            |                  |                    |                |           |
|------------------------------------|------------------|--------------------|----------------|-----------|
| Part / Item                        | Component Name   | Quantity           | Operation      | Container |
| M303R2.000                         | 303 Round Bar 2" | 1.8000 ft (.15 ea) | 100-Doosan - 1 | 5221909   |
| Job Allocations                    |                  |                    |                |           |
| Operation                          | Component Part   | Required           | Inventory      | Allocated |
| 100-Doosan - 1                     | M303R2.000       | 2                  | 13             | 0         |
| Part Specifications                |                  |                    |                |           |
| Specifications could not be found. |                  |                    |                |           |

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|--------------------------------------------|---------------|---------------------|---------|
| <b>DART AEROSPACE LTD</b>                  |               | <b>Work Order:</b>  | 202249  |
| <b>Description:</b> EAPS P2 Engine Fitting |               | <b>Part Number:</b> | D4931-5 |
| <b>Inspection Dwg:</b> D4931               | <b>Rev:</b> A | <b>Page 1 of 1</b>  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance          | Actual Dimension | Accept | Reject | Method of Inspection | Comments  |
|-------------------|--------------------|------------------|--------|--------|----------------------|-----------|
| 1-1/16-12 UN 2A   | N/A                | 1-1/16-12        | ✓      |        | Wire loss            | + Nut Ref |
| 37°               | +/-0.5°            | 37               |        |        | Pross                |           |
| 0.185             | +/-0.010           | .185             |        |        | Caliper              |           |
| 0.315             | +/-0.010           | .315             |        |        | Caliper              |           |
| 0.424             | +/-0.010           | .430             |        |        | Caliper              |           |
| 0.250             | +/-0.010           | .246             |        |        | Caliper              |           |
| 0.938             | +/-0.010           | .939             |        |        | Caliper              |           |
| 1.927 Ref         | +/-0.010           | 1.928            |        |        | Caliper              |           |
| 0.25              | +/-0.030           | .249             |        |        | Caliper              |           |
| 0.13              | +/-0.030           | .130             |        |        | Caliper              |           |
| 0.907             | +/-0.010           | .909             |        |        | Caliper              |           |
| 0.078             | +/-0.010           | .082             |        |        | Caliper              |           |
| Ø0.063            | +0.004/-0.001      | .066             |        |        | Caliper              |           |
| 0.13 x 45°        | +/-0.030 x +/-0.5° | 1/8 x 45°        |        |        | Caliper              |           |
| 0.34              | +/-0.030           | .345             |        |        | Caliper              |           |
| 0.25              | +/-0.030           | .246             |        |        | Caliper              |           |
| Ø0.238            | +0.005/-0.001      | 0.239            | ✓      |        | Vernier JVD5         |           |
| 35°               | +/-0.5°            | 35               |        |        | Pross                |           |
| 0.532             | +/-0.010           | 0.532            | ✓      |        | Vernier JVD5         |           |
| 1.063             | +/-0.010           | 1.061            |        |        | Caliper              |           |
| 0.513             | +/-0.010           | 0.513            | ✓      |        | Vernier JVD5         |           |
| 0.749             | +/-0.010           | .748             |        |        | Caliper              |           |
| 1.025             | +/-0.010           | 1.025            | ✓      |        | Vernier JVD5         |           |
|                   |                    |                  |        |        |                      |           |
|                   |                    |                  |        |        |                      |           |
|                   |                    |                  |        |        |                      |           |
|                   |                    |                  |        |        |                      |           |

|                                 |                                |                              |
|---------------------------------|--------------------------------|------------------------------|
| <b>Measured by:</b> [Signature] | <b>Audited by:</b> [Signature] | <b>Preliminary Approval:</b> |
| <b>Date:</b> 11/14/19/11/04     | <b>Date:</b> 12/11/04          | <b>Date:</b>                 |
| <b>Rev</b>                      | <b>Date</b>                    | <b>Change</b>                |
| A                               | 14.06.24                       | New Issue                    |
| <b>Revised by:</b> [Signature]  |                                | <b>Approved:</b> [Signature] |
| KJ                              |                                |                              |



Entered: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

| DISPOSITION                                    |                                                       | DEPARTMENT/PROCESS                                       |                                             |                                              |                                      |
|------------------------------------------------|-------------------------------------------------------|----------------------------------------------------------|---------------------------------------------|----------------------------------------------|--------------------------------------|
| Job: _____                                     | Rework <input type="checkbox"/>                       | Skid-tube <input type="checkbox"/>                       | Cross tube <input type="checkbox"/>         | Eng. (Non-AW) <input type="checkbox"/>       | Engineering <input type="checkbox"/> |
| Part No. _____                                 | Scrap <input type="checkbox"/>                        | Machining <input type="checkbox"/>                       | Small Fab <input type="checkbox"/>          | Prod. Eng. Coord. <input type="checkbox"/>   | Water Jet <input type="checkbox"/>   |
|                                                | Use-as-is <input type="checkbox"/>                    | Large Fab <input type="checkbox"/>                       | Finishing <input type="checkbox"/>          | Rec/Store/Packaging <input type="checkbox"/> | Supplier <input type="checkbox"/>    |
|                                                |                                                       |                                                          |                                             | Quality <input type="checkbox"/>             |                                      |
| Date: _____                                    | Sequence #: _____                                     | QTY Affected: _____                                      |                                             | MRB (QS1042) _____                           |                                      |
| Description Work Order Deviation               |                                                       | Disposition                                              |                                             |                                              |                                      |
|                                                |                                                       |                                                          |                                             |                                              |                                      |
|                                                |                                                       |                                                          |                                             |                                              |                                      |
|                                                |                                                       |                                                          |                                             |                                              |                                      |
| Root Cause                                     |                                                       | FAULT CATEGORY                                           |                                             |                                              |                                      |
| Operator <input type="checkbox"/>              | Pressure/Forced <input type="checkbox"/>              | Contamination <input type="checkbox"/>                   | Power Loss/Surge <input type="checkbox"/>   | Positioned Wrong <input type="checkbox"/>    |                                      |
| Manufacturing Process <input type="checkbox"/> | Bending <input type="checkbox"/>                      | Misaligned/off center <input type="checkbox"/>           | Folio/Program <input type="checkbox"/>      | Outside Tolerance <input type="checkbox"/>   |                                      |
| Equip/Tooling <input type="checkbox"/>         | Crushing <input type="checkbox"/>                     | BOM/Route <input type="checkbox"/>                       | Grain Direction <input type="checkbox"/>    | Drawing <input type="checkbox"/>             |                                      |
| Handling/Preservation <input type="checkbox"/> | Cracks <input type="checkbox"/>                       | Broken/Damage/Defect <input type="checkbox"/>            | Weld <input type="checkbox"/>               | Finish <input type="checkbox"/>              |                                      |
| Material <input type="checkbox"/>              | Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> | Incomplete/Unclear Instructions <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/>   |                                      |
| Product Improvement <input type="checkbox"/>   | Marks/Chatter <input type="checkbox"/>                | Drill Holes <input type="checkbox"/>                     | Out of Sequence <input type="checkbox"/>    | Misread <input type="checkbox"/>             |                                      |
| Process Improvement <input type="checkbox"/>   | Mislabeled <input type="checkbox"/>                   | Fit/Function <input type="checkbox"/>                    | Off-set/Set-up <input type="checkbox"/>     |                                              |                                      |
| Human Factors <input type="checkbox"/>         | Other/Details: _____                                  |                                                          |                                             |                                              |                                      |
| Completed By                                   |                                                       | Lead hand / Supervisor                                   |                                             |                                              |                                      |
|                                                |                                                       | QC / QA Coordinator                                      |                                             |                                              |                                      |